

Date: Monday, 23/02/2009 12:45:49 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET MOD KIT
Job Number : 45978	
Estimate Number : 11337	
P.O. Number :	Part Number : DSI9268011
This Issue : 23/02/2009 S.O. No. :	Drawing Number : D3230 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A C <i>low 03.11</i>
Previous Run : 43935	Material :
Written By :	Due Date : 30/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.02.23</u>	
Comment : Est Rev:B 03.11.19 Kit redesign KJ/DS Est Rev:C 08-12-02 add QC9 and QC5 DD verified by:EC	

Additional Product D3759-1 - Sat 11/11/08 *Cpl 09.03.02*
D2327-3 - Sat 04/04/09 *Cpl 09.03.02*



Job Number:



PARTS NOT SCANNED

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------

*Hg for JUD 09/03/10***Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP DSI 9288-011 CHG 0023

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------

**Comment:** Qty.: 25.8300 f(s)/Unit Total: 25.8300 f(s)

Material: 304/316 SS Tube 0.065" wall

(M304TS0.750W.065)

Batch: M110839*Cpl 09.03.02*

3.0	D23273	Spacer Bushing
-----	--------	----------------

**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2327-3	Spacer Bushing	<u>B44365</u>

Cpl 09.03.02

4.0	M304EX07516F	Expanded Metal Flat SS
-----	--------------	------------------------

**Comment:** Qty.: 5.2500 sf(s)/Unit Total: 5.2500 sf(s)

Pick:

Qty Part Number	Description	Batch
5sf M304EX0.75-16F	Mesh	<u>M110861</u>

Cpl 09.03.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 12:45:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET MOD KIT

Job Number: 45978

Part Number: DSI9268011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230

2-Fabricate basket wedge assembly as per D3230

A/R SS ROD Batch: M106762

2-Deburr & Remove all Markings From Material

P109-03-02

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

**ENGINEERING
APPROVAL**

PD 09-03-03

7.0

QC5

INSPECT WORK TO CURRENT STEP



Positive Recall
EFFECTIVE 09-03-03



Comment: INSPECT WORK TO CURRENT STEP

RELEASED 09-03-03 DATE 09-03-03

Mar B.

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

2125

OVEN TEMPERATURE:

400°

FINISH TIME:

2155

2ND COAT:

START TIME:

N/A

OVEN TEMPERATURE:

FINISH TIME:

FL 09/03/04

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 12:45:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET MOD KIT

Job Number: 45978

Part Number: DSI9268011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

11.0

AN417A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

5 AN4-17A

Bolt

M109061

12.0

AN960JD416

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

5 AN960JD416

Washer

M110523

13.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

5 MS21042L4

Nut (or -4)

M109282

14.0

DSI9053011

SEE DSI 9053011



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

1 DSI 9053-011

Hinge Change Kit

B25202

ch 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 12:45:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET MOD KIT

Job Number: 45978

Part Number: DSI9268011

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/03/10 (1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Dsi 9268-011

Location: _____

PPP Rev: B

09/03/10 (1)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10 *[Signature]*

Job Completion



MF
09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3230-041	BASKET WEDGE ASSEMBLY
3	1	D2221-1	RIB
4	2	D2232-3	BASKET HINGE
5	2	D2327-3	SPACER BUSHING
6	1	D3230-1	RIB
7	1	D3230-2	RIB
8	1	D3230-3	RIB
9	1	D3230-4	RIB
10	4	D3230-5	RIB
11	1	D3230-7	RIB
12	2	D3230-9	SIDE MESH
13	1	D3230-11	FRONT MESH
14	5	D3759-1	BUSHING

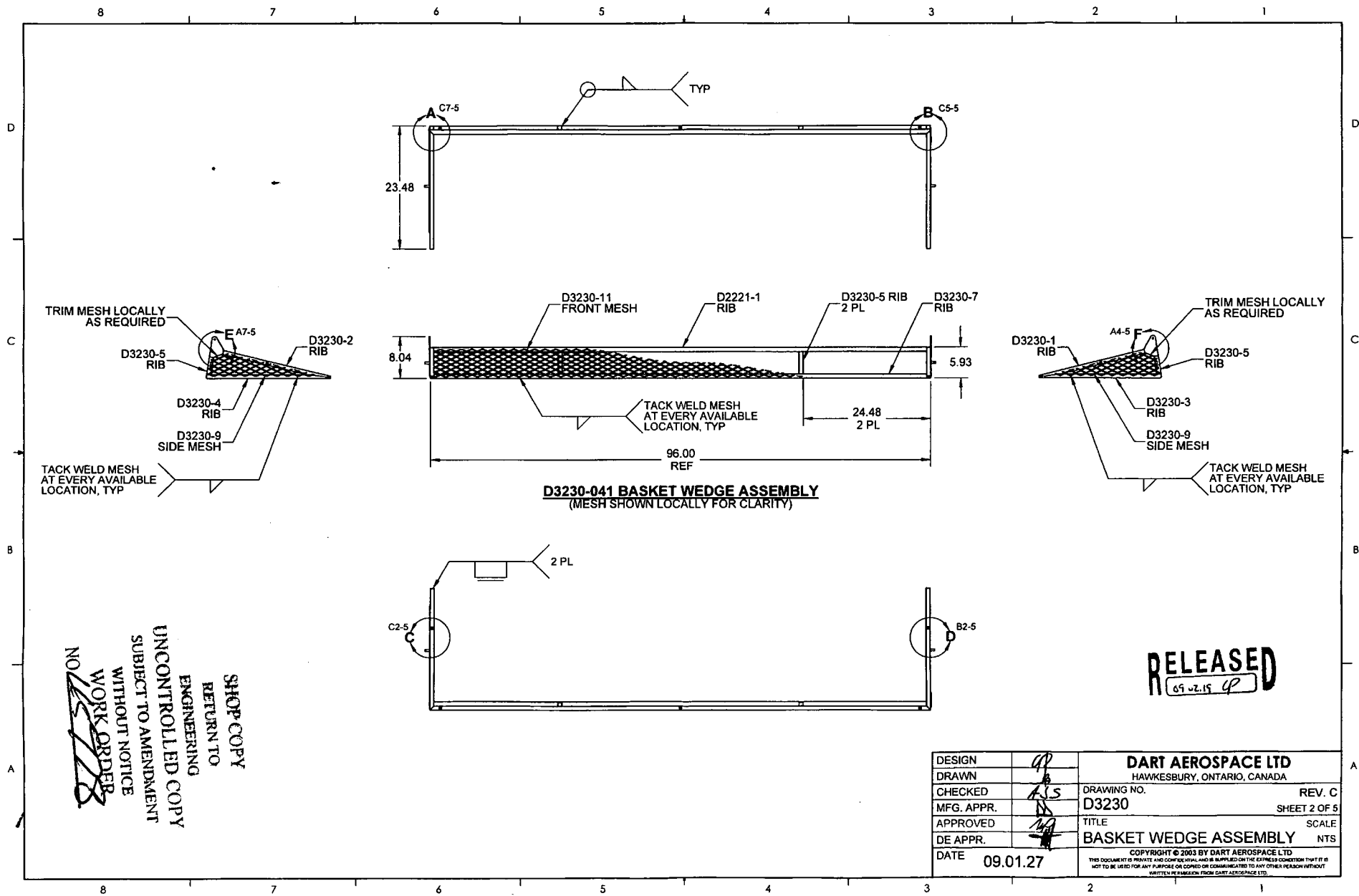
D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
09.02.19 CP
PER ECN 09-534

C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	06.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3230	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	<small> COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3230-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 19.8 lbs
 - 8) WELDING: PER DART QSI 004

NO. 15478
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SUBJECT TO AMENDMENT
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ENGINEERING
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SHIP COPY
WOLKOFF
09/01/27



TRIM MESH LOCALLY
AS REQUIRED

D3230-5 RIB

D3230-2 RIB

D3230-4 RIB

D3230-9 SIDE MESH

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION, TYP

TRIM MESH LOCALLY
AS REQUIRED

D3230-1 RIB

A4-5

D3230-5 RIB

D3230-3 RIB

D3230-9 SIDE MESH

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION, TYP

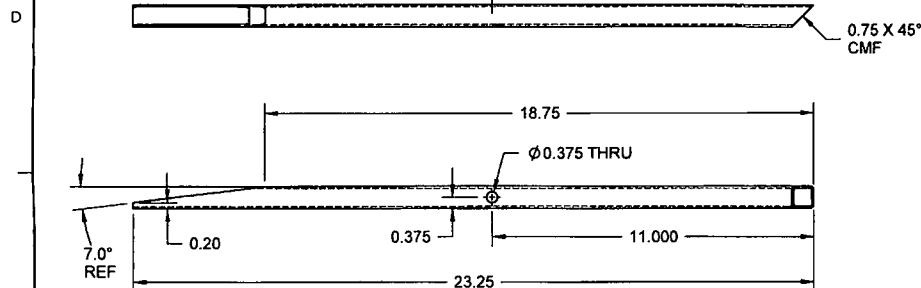
D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
09.01.19

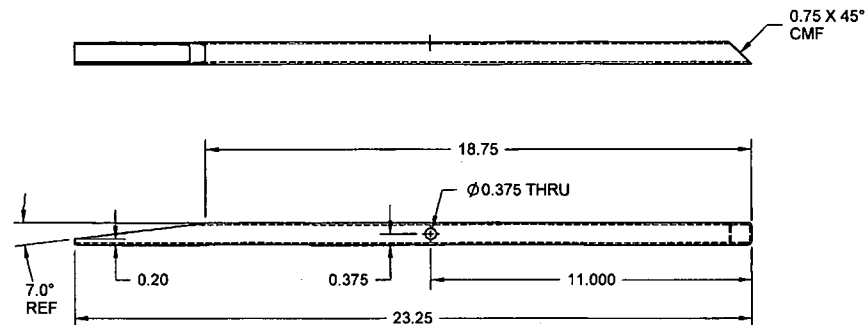
SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 15778

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3230	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

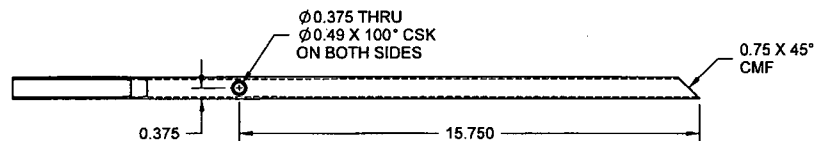
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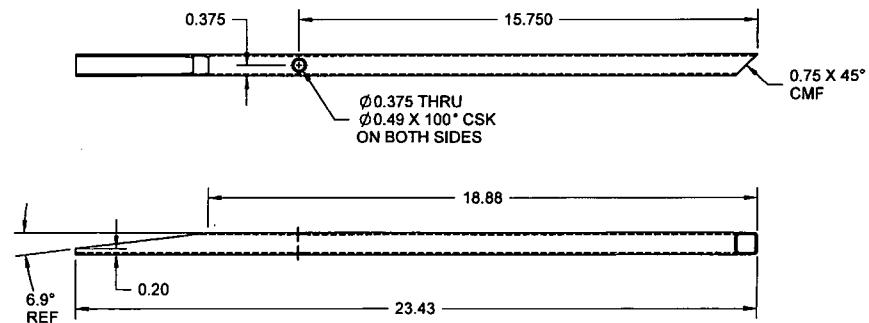
D3230-1 RIB



D3230-2 RIB



D3230-3 RIB

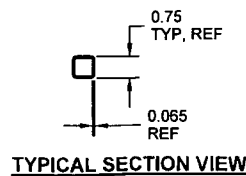


D3230-4 RIB

WORK ORDER
NO. 158718
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHIP COPY
D3230

NOTES:

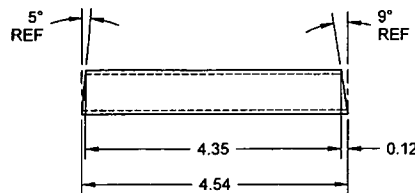
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs EACH



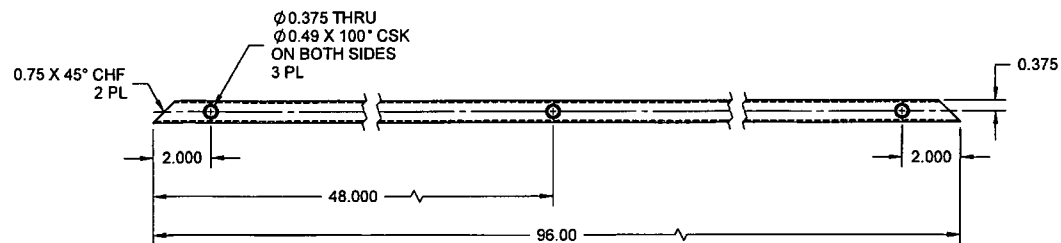
RELEASED
09.02.19 4P

DESIGN		DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO. D3230	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED	MS	BASKET WEDGE ASSEMBLY	SCALE
DE APPR.			NTS
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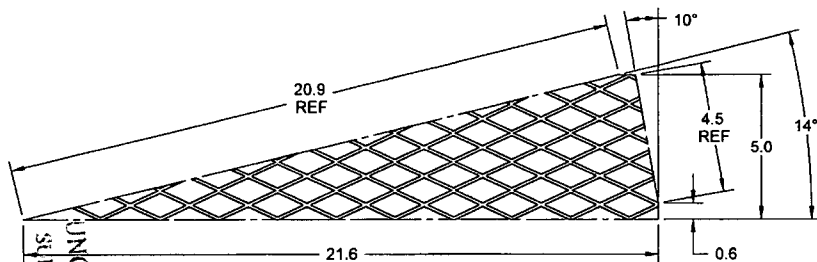
8 7 6 5 4 3 2 1



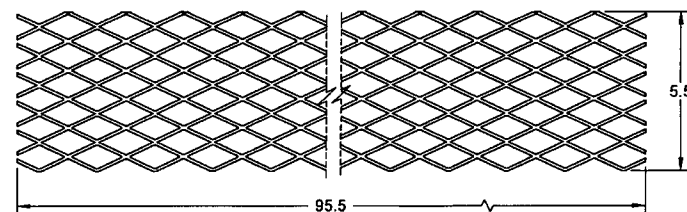
D3230-5 RIB



D3230-7 RIB



D3230-9 SIDE MESH



D3230-11 FRONT MESH

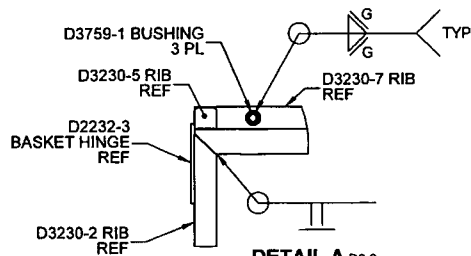
NOTES:

- 1) MATERIAL:
D3230-5/-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL
REF. DART SPEC. M304EX0.75-16F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs
D3230-9 = 0.20 lbs; D3230-11 = lbs

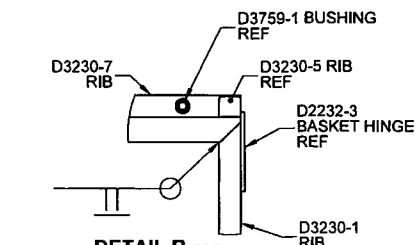
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09.01.27

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PA	DRAWING NO.	REV. C
CHECKED	ALS	D3230	SHEET 4 OF 5
MFG. APPR.	DS	TITLE	SCALE
APPROVED	DS	BASKET WEDGE ASSEMBLY	NTS
DE APPR.	TH	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.01.27		

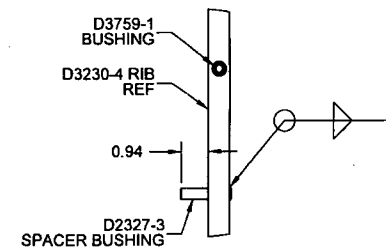
NO. 15928
WORK ORDER
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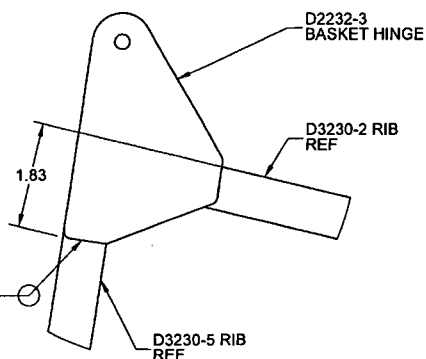
DETAIL A D6-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



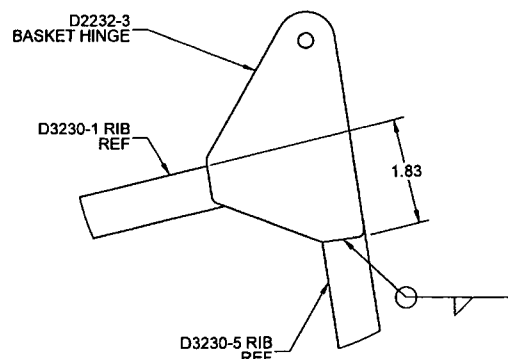
DETAIL B D3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



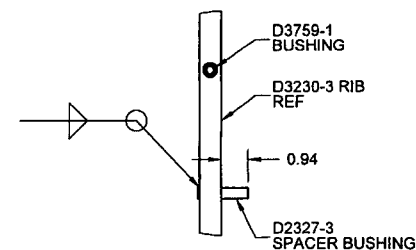
DETAIL C B6-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



DETAIL E C7-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL F C2-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL D B3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X

RELEASED
09-02-15

NO. 25278
WORK ORDER
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DESIGN	gp	DART AEROSPACE LTD	
DRAWN	gk	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	DS	D3230	SHEET 5 OF 5
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	BASKET WEDGE ASSEMBLY	
DATE	09.01.27	NTS	
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ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 09.02.19	Job No.: 00283	ADR Yes/No: Y	ADR Date: 09.01.23	ECN #: 09- 534
Product No.: D205-541		Created By: <i>[Signature]</i>	Approved By: <i>[Signature]</i>	
Product Name: HELI-UTILITY-BASKET		Checked By: <i>[Signature]</i>	General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	DD/EC	
Production Document Control	Y	JLD	
Customer Technical Support	Y	DS	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	N		
Marketing	Y	SW	
Customer Order Processing	N		

Reason for Change:
 REDESIGNED BASKET WEDGE TO PROVIDE MORE CLEARANCE BETWEEN INBOARD EDGE OF WEDGE AND A/C SLIDING DOOR.

Documents Affected:
 RELEASE D3230 AND DSI 9268 BOTH AT REV. C.

PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	MB		04.01.22 <i>[Signature]</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19 <i>[Signature]</i>
10	Update Controlled PDF Files	Y	KJ		09.02.19 <i>[Signature]</i>
11	Update Master Document List (MDL)	Y	MB		09.02.12 <i>[Signature]</i>
12	Update Document Record (DR)	Y	KJ	Rev. P	09.02.19 <i>[Signature]</i>
13	Update Product Development Summary	Y	MP		
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N	KJ	BOM CHANGE	
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	DSI 9268-011 NOW @ CHG 003	09.02.19 <i>[Signature]</i>
18	Create / Update PPP's	Y	KJ	AS REQUIRED.	09.02.19 <i>[Signature]</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19 <i>[Signature]</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19 <i>[Signature]</i>
22					
23					

Description / Action:
 TO ADDRESS NCR#09-010:
 - REQUIRES MANUFACTURING OF ONE D3230-041;
 - STAMP W/O WITH "POSITIVE RECALL" AT STEP 7 AS IT WILL REQUIRE 'FIT, FORM & FUNCTION' TEST FIT FOR ENGINEERING;
 - COMPLETE WORK UPON ENGINEERING SIGN-OFF AND SHIP DSI 9268-011 TO BLACKCOMB HELICOPTERS PER NCR#09-010.

ECN Verified & Complete: _____ Date: _____

Date: Tuesday, 10/03/2009 11:20:54 AM

User: Linda Lacelle

Bill of Manufacturing

Part Number		: DSI9268011	Revision		: C	
Drawing Name		: BASKET MOD KIT	Default Qty.		: 1	
Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	DC	DOCUMENT CONTROL	0.00	Hours	43.00	0.00
2	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00
3	D3230041	BASKET WEDGE ASSEMBLY	1.00	Each	0.00	0.00
▪ 1	M304TS0750W065	Material: 304/316 SS Tube 0.065" wall	25.83	f	2.28	59.10
▪ 2	M304EX07516F	Pick:	5.25	sf	2.90	15.23
▪ 3	D22323	Basket Hinge	2.00	Each	3.74	7.49
▪ 4	D23273	Pick:	2.00	Each	1.32	2.64
▪ 5	D37591	Bushing	5.00	Each	3.93	19.65
▪ 6	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	0.00	Hours	90.00	0.00
▪ 7	QC9	VISUAL WELDING INSPECTION	0.00	Hours	26.00	0.00
▪ 8	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	0.00	0.00
▪ 9	POWDER COATING	POWDER COATING	0.00	Hours	90.00	0.00
▪ 10	QC3	INSPECT POWDER COAT/CHEMICAL	0.00	Hours	43.00	0.00
▪ 11	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	0.00	0.00
▪ 12	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00
▪ 13	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
4	DSI9053011	Pick: Packing Kit	1.00	Each	0.00	0.00
5	AN417A	Pick: Packing Kit	5.00	Each	0.20	1.00
6	AN960JD416	Pick: Packing Kit	5.00	Each	0.03	0.16
7	MS21042L4	Pick: Packing Kit	5.00	Each	0.06	0.34
8	QC4	INSPECT 100% KITS FOR COMPLETENESS	0.00	Hours	26.00	0.00
9	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00
10	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
Total BOM Cost						105.64

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541

REF. CANADIAN STC: SH96-120

REF. FAA STC: SR00696NY

EASA STC: EASA.IM.R.S.0.1242

THE PURPOSE OF THE DSI 9268-011 BASKET MODIFICATION KIT IS TO INCREASE THE VOLUME OF THE D205-541-043/-044 BASKETS. NOTE THAT D205-541-041 BASKETS MUST BE CONVERTED INTO D205-541-043/-044 PER DSI 9226 BEFORE PERFORMING THIS MODIFICATION.

TO INSTALL THE DSI 9268-011 KIT:

- △ 1) FOR BASKETS WITH:
- A) PIANO HINGES: INSTALL THE DSI 9053-011 HINGE CHANGE KIT AND SEPARATE LID FROM BASE.
OR
- B) DSI 9053-011 HINGE CHANGE KIT ALREADY INSTALLED: NO CHANGE IS REQUIRED. SEPARATE LID FROM BASE.
OR
- C) HINGE PLATES WELDED TO LID & BASE: NO CHANGE IS REQUIRED. SEPARATE LID FROM BASE.
- 2) ATTACH LID TO D3230-041 BASKET WEDGE ASSEMBLY. MOVE D2332-041 PROP ASSEMBLY FROM BASKET BASE TO WEDGE ASSEMBLY PER FIGURE 1.
- 3) LOCATE D3230-041 BASKET WEDGE ASSEMBLY COMPLETE WITH BASKET LID ON THE EXISTING BASKET BASE. TEMPORARILY CLAMP IN PLACE AND CHECK FOR PROPER LATCHING OF THE EXISTING LID WITH THE WEDGE. ADJUST LOCATION OF WEDGE ASSEMBLY TO ENSURE PROPER LATCHING. SHIM AS REQUIRED TO ENSURE PROPER LATCHING.
- 4) TRANSFER LOCATION OF 1/4" ATTACHMENT HOLES FROM WEDGE TO EXISTING BASE.
- 5) REMOVE WEDGE AND DRILL Ø0.266" HOLES THROUGH THE EXISTING BASE. DEBURR HOLES.
- 6) INSTALL WEDGE USING AN4-17A BOLTS, AN960JD416 WASHERS, AND MS21042L4 NUTS PROVIDED (5 PLACES TOTAL). NOTE THAT THE BOLTS IN SOME LOCATIONS MAY HAVE TO BE INSTALLED WITH THE NUTS ON TOP BECAUSE OF CLEARANCE ISSUES.
- 7) ADJUST WEIGHT AND BALANCE AS FOLLOWS:

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
DSI 9268-011	20 lb	± 63.13 in	± 1263 in-lb	132.25 in	2645 in-lb
BASKET MODIFICATION KIT	9 kg	± 1.60 m	± 14.4 m-kG	3.36 m	30 m-kG

DSI 9268-011 KIT PARTS LIST:

QTY -011	P/N	DESCRIPTION
X	DSI 9268-011	BASKET MODIFICATION KIT
1	D3230-041	BASKET WEDGE ASSEMBLY
1	DSI 9053-011	HINGE CHANGE KIT
5	AN4-17A	BOLT
5	AN960JD416	WASHER
5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 09.02.02
CERT. NO.: SH96-120
ISSUE NO.: 3

C	UPDATED TO CURRENT DWG STANDARDS; REVISED INSTALLATION STEP #1. CORRECTED TYPO (DSI 9053-011 WAS DSI 9052-011). REASON: REDESIGN OF D3230-041 (REF. NCR#09-010).	MB	09.02.02
B	CHANGE ORIENTATION OF WEDGE	CP	03.11.19
A	NEW ISSUE	CP	03.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		DSI 9268	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION KIT	NTS
DATE	09.02.02	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

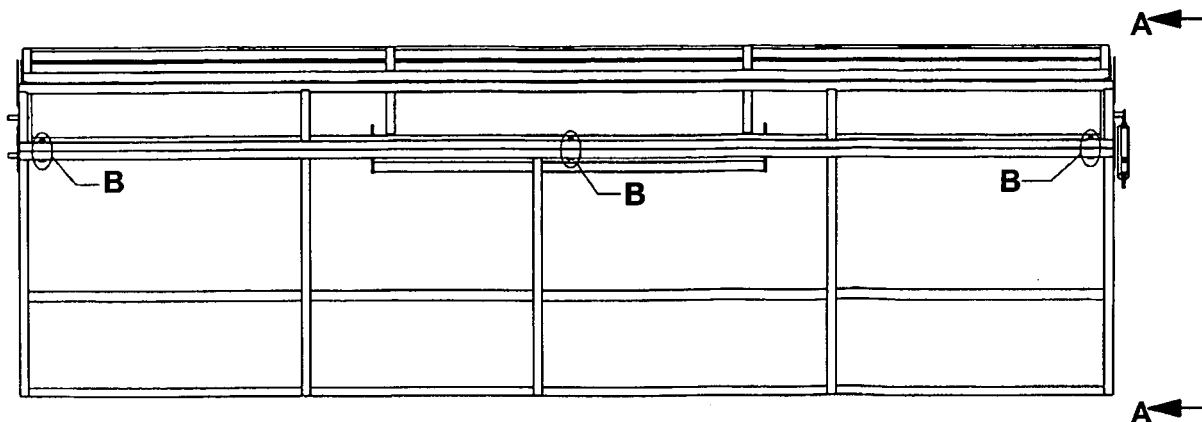
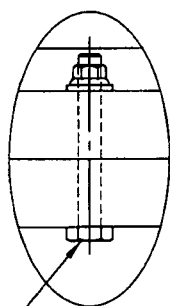
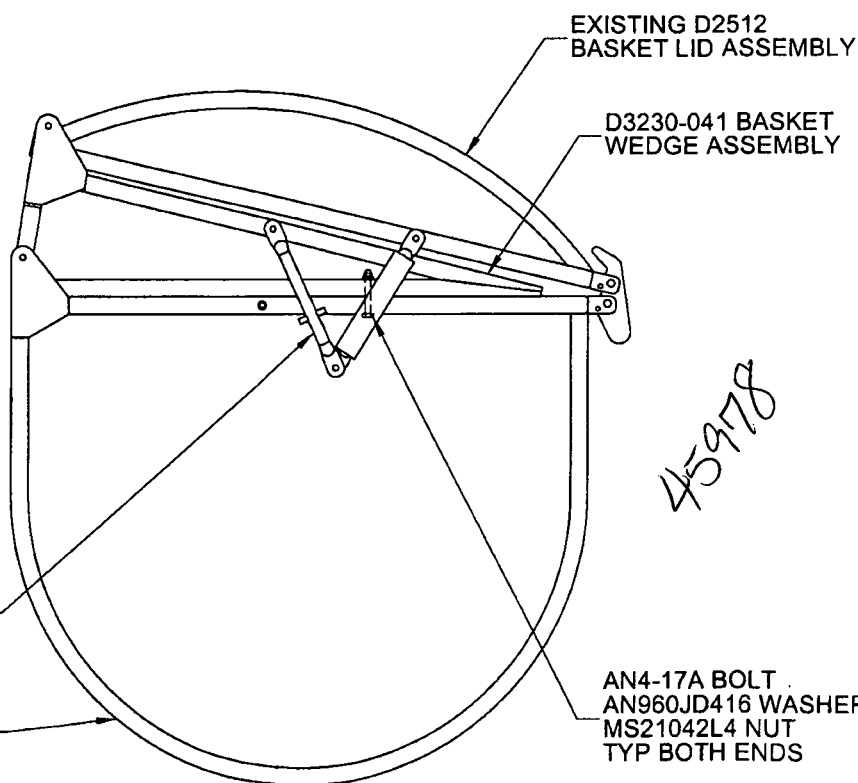


FIGURE 1 - LOOKING OUTBOARD
(MESH NOT SHOWN FOR CLARITY)



AN4-17A BOLT
AN960JD416 WASHER
MS21042L4 NUT

DETAIL B
3 PL, SCALE 8X









VIEW A-A
(MESH NOT SHOWN FOR CLARITY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.02.02
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